

Date: Monday, 20/04/2009 9:58:53 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : GUSSET ASS'Y
 Job Number : 47274
 Estimate Number : 13866
 P.O. Number :
 This Issue : 20/04/2009 S.O. No. :
 Prsht Rev. : NC Part Number : D3929042
 First Issue : / / Type : SMALL / MED FAB Drawing Number : D3929 PRELIMINARY
 Previous Run : Drawing Revision : A PRELIM
 Material :
 Due Date : 27/04/2009 Qty: 2 Um: Each
 Written By :
 Checked & Approved By : JW 09.04.20
 Comment : Est Rev:A 09-04-20 new issue EC verified by:DD

POSITIVE
RECALL

Additional Product

RELIMINARY ISSUE

09.04.17
Per ECN #09-5701

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S200A 304/316 Sheet



0.125
09.04.20

PART NOT PULLED



Comment: Qty.: 0.4725 sf(s)/Unit Total : 0.9450 sf(s)

304/316 Sheet 0.125" thick

Batch: 111018 B9-4-20

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3929

Dwg Rev: DRF

Prog Rev: Lim

B9-4-20

2

2-Deburr if necessary

B9-4-20

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



B9-4-20



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



09-04-21 (2)



Comment: SECOND CHECK

5.0 D39071 Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bushing

Batch: B47105

PD 09-04-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 20/04/2009 9:58:53 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GUSSET ASS'Y

Job Number: 47274

Part Number: D3929042

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld bushings D3907-1 as per dwg D3929

316L rod batch: M108160

PD 09-04-21 (2)

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

CP 09-04-21

(2)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09-04-21 (2)

ENGINEERING
APPROVAL

09-04-21 (2)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify as per dwg and Stock

Location: _____

PPP 47636

SS 09/04/30 (2)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/30 (2)

Job Completion



POSITIVE RECALL
EFFECTIVE 09-04-20

AUTH

DATE 09-04-21

MF

09-04-20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

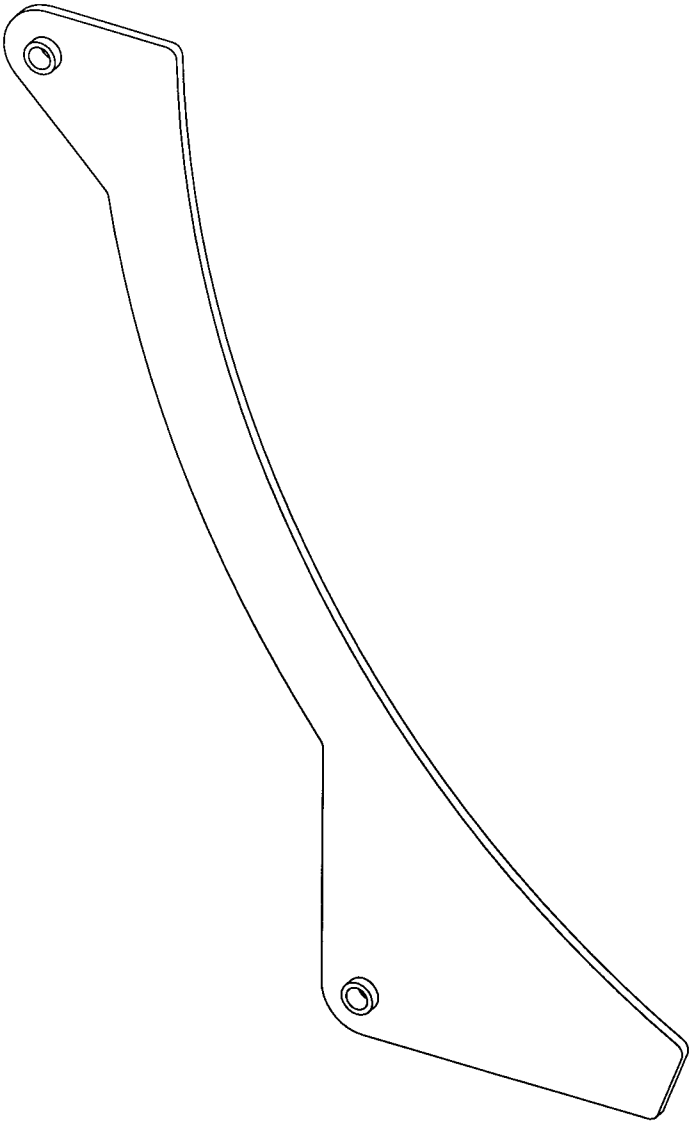
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

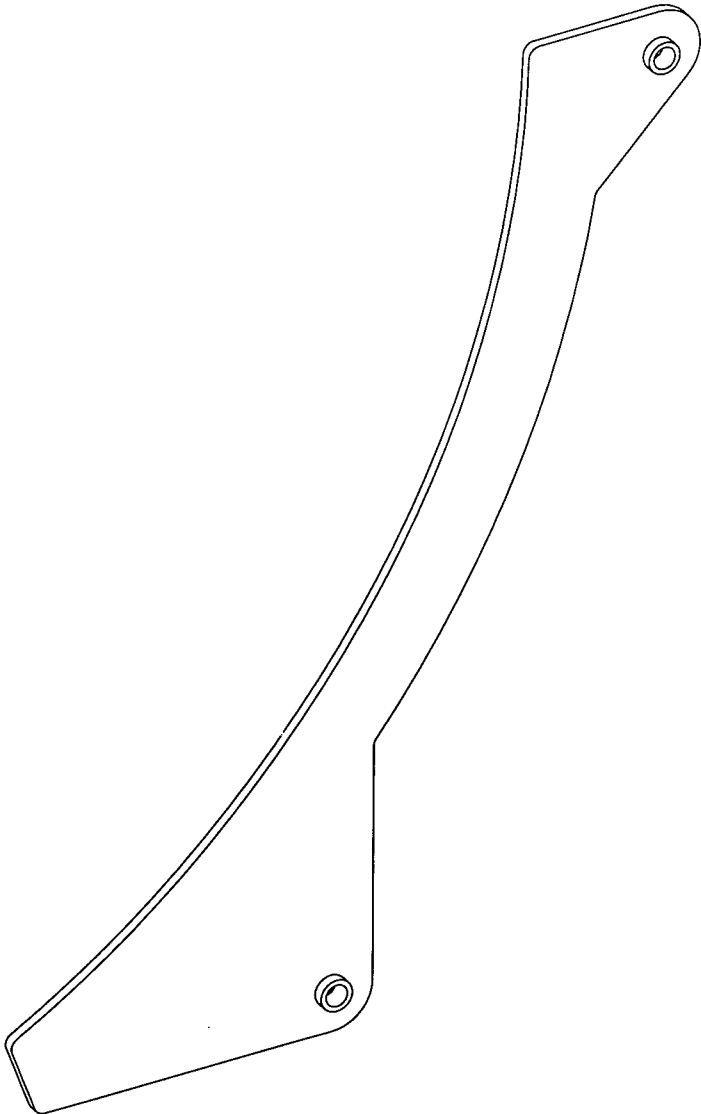
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3929-041	GUSSET ASSEMBLY
2		X	D3929-042	GUSSET ASSEMBLY
11	2	2	D3907-1	BUSHING
12	1	1	D3929-1	SUPPORT GUSSET



D3929-041 GUSSET ASSEMBLY



D3929-042 GUSSET ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 47214

PRELIMINARY
ISSUE
09.04.12

- NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3929-04X" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.73 lbs EACH
8) WELDING: PER DART QSI 004

A	NEW ISSUE	MB	09.04.03
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3929	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		GUSSET ASSEMBLY	NTS
DATE	09.04.03	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

D3929-1
SUPPORT GUSSET
2 PL

0.25
2 PL, REF

D3907-1
BUSHING
2 PL

D3929-1
SUPPORT GUSSET
REF

D3929-041 GUSSET ASSEMBLY

D3929-1
SUPPORT GUSSET
2 PL

2 PL

D3907-1
BUSHING
2 PL

D3929-1
SUPPORT GUSSET
REF

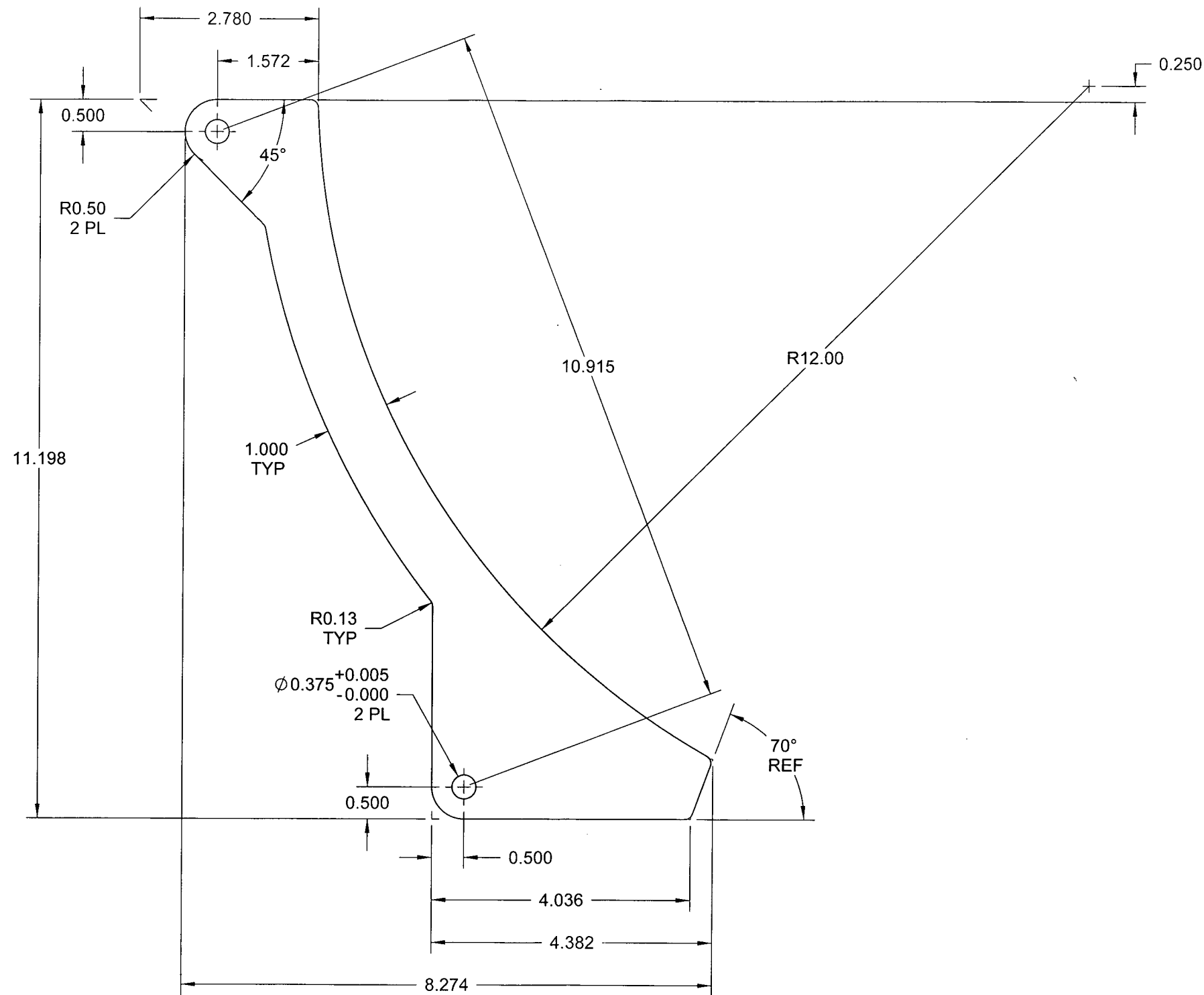
0.25
2 PL, REF

D3929-042 GUSSET ASSEMBLY

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WITHOUT NOTICE
WORK ORDER
NO. 47219

**PRELIMINARY
ISSUE** 09.04.17

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3929	SHEET 2 OF 3
APPROVED		TITLE	SCALE
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D3929-1 SUPPORT GUSSET

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 41274

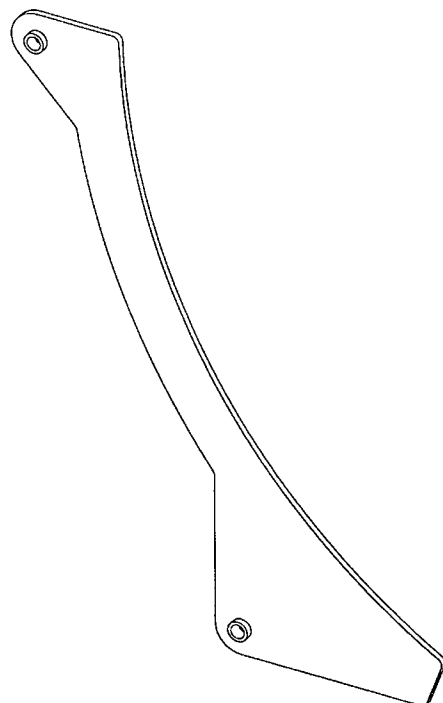
**PRELIMINARY
ISSUE**
09.04.12

NOTES:

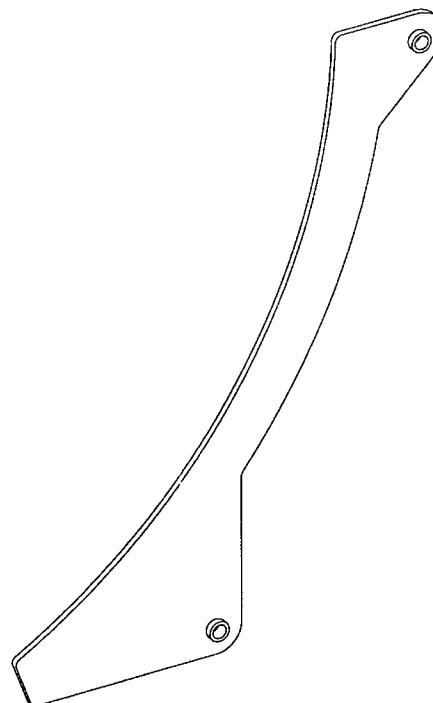
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
11 GAUGE (0.125 THICK)
REF. DART SPEC. M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.72 lbs

DESIGN		DART AEROSPACE LTD	
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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3929	SHEET 3 OF 3
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DE APPR.		GUSSET ASSEMBLY	NTS
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ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3929-041	GUSSET ASSEMBLY
2		X	D3929-042	GUSSET ASSEMBLY
11	2	2	D3907-1	BUSHING
12	1	1	D3929-1	SUPPORT GUSSET



D3929-041 GUSSET ASSEMBLY



D3929-042 GUSSET ASSEMBLY

47274

RELEASED
9/24/12

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3929-04X" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.73 lbs EACH
 - 8) WELDING: PER DART QSI 004

A	NEW ISSUE	MB	09.04.03
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.04.03		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3929
REV. A
SHEET 1 OF 3
TITLE GUSSET ASSEMBLY
SCALE NTS

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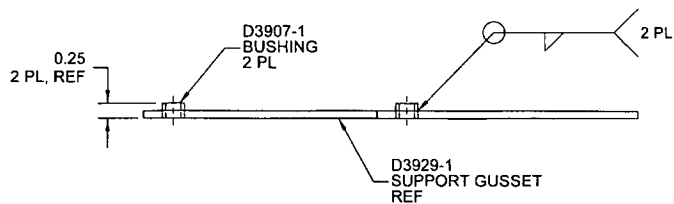
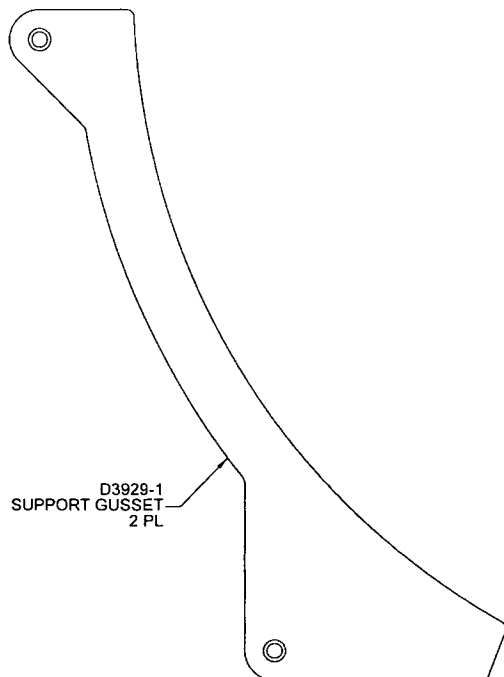
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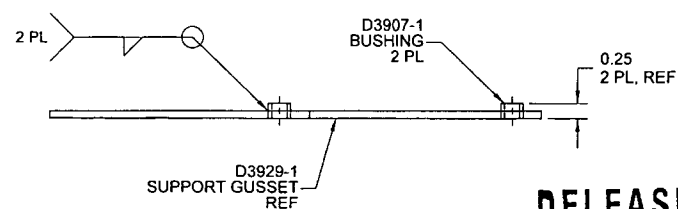
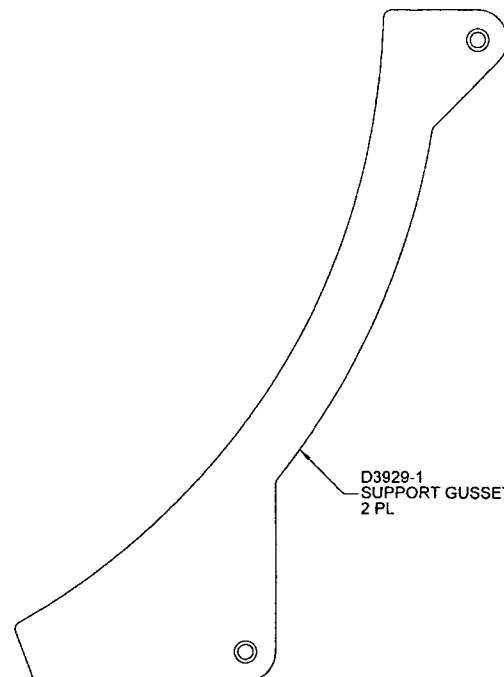
C

B

A

**D3929-041 GUSSET ASSEMBLY**

47274

**D3929-042 GUSSET ASSEMBLY****RELEASED**
09/04/22 AD

DESIGN		DART AEROSPACE LTD	
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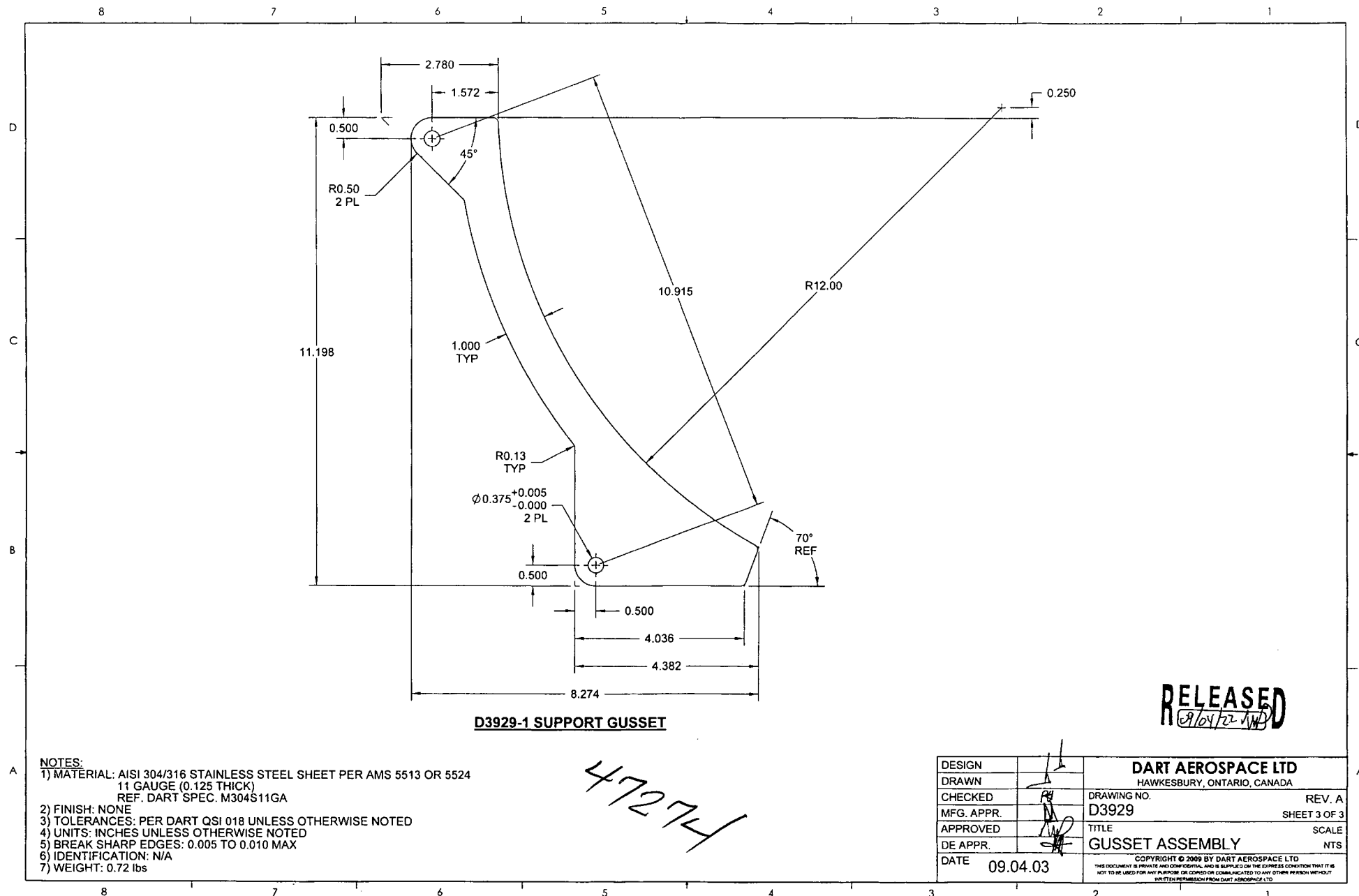
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1

A



RELEASED
09/04/22

- NOTES:**
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 - 7) WEIGHT: 0.72 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3929	SHEET 3 OF 3
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